

Need for Tues. 27/02

Dart Aerospace Ltd.

Date: Friday, 2/23/2007 8:31:21 AM  
User: Kim Johnston

SAMS FABTS  
Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SUPPORT BRACKET	
Job Number	: 30877				
Estimate Number	: 10260				
P.O. Number	: N/A		Part Number	: D23623	
This Issue	: 2/23/2007	S.O. No. : N/A	Drawing Number	: D2362 REV E1	
Prsht Rev.	: NC		Project Number	: N/A	
First Issue	: N/A		Drawing Revision	: E1	
Previous Run	: 29775		Material	: N/A	
Written By			Due Date	: 2/28/2007	
Checked & Approved By			Qty:	10	Um: Each
Comment	: Est: G 00.05.18 Added inspection level 8 EC				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D2265	Step Support Casting	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) Step Support Pick: Qty Part Number Description Batch 1 D2265 Step Support B29807	
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: Machine per folio D2362-3	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: Inspect Level 2	
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr	
6.0	POWDER COATING	POWDER COATING	
		Comment: POWDER COATING Powder Coat Gloss White (Ref 4.3.5.1)as per Dart QSI 005 4.3	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/02/28  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 2/23/2007 8:31:21 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: SUPPORT BRACKET
Job Number: 30877		Part Number: D23623
Job Number:		
Seq. #:	Machine Or Operation:	Description :
7.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION 
Comment: INSPECT POWDER COAT		
8.0	D23971	Rubber Cushion 
Comment: Qty.: 1.0000 Each(s)/Unit Total : ( 8.0000 Each(s) 10 ) Rubber Cushion Pick: Qty Part number      Description      Batch 1      D2397-1      Rubber      B29809 x9 ✓      B30971 x1		
9.0	D23973	Rubber Cushion 
Comment: Qty.: 1.0000 Each(s)/Unit Total : ( 8.0000 Each(s) 10 ) Rubber Cushion Pick: Qty Part number      Description      Batch 1      D2397-3      Rubber      B29810 x9 ✓      B30972 x1		
10.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 
Comment: SMALL & MEDIUM FAB RESOURCE 1 Bond rubber D2397-1 followed by D2397-3 using contact cement as per Dwg D2362      Batch M102S65      ml01/02/26 x10		
11.0	QC5	INSPECT WORK TO CURRENT STEP 
Comment: INSPECT WORK TO CURRENT STEP      SB 07/02/27		
12.0	PACKAGING 1	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: C7/1/28 (10)		
13.0	QC21	FINAL INSPECTION/W/O RELEASE 
Comment: FINAL INSPECTION/W/O RELEASE      (10) 07/02/28		
Job Completion		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	30877
Description: Step Support Bracket	Part Number:	D2362-3
Inspection Dwg: D2362      Rev: E1		Page 1 of 1

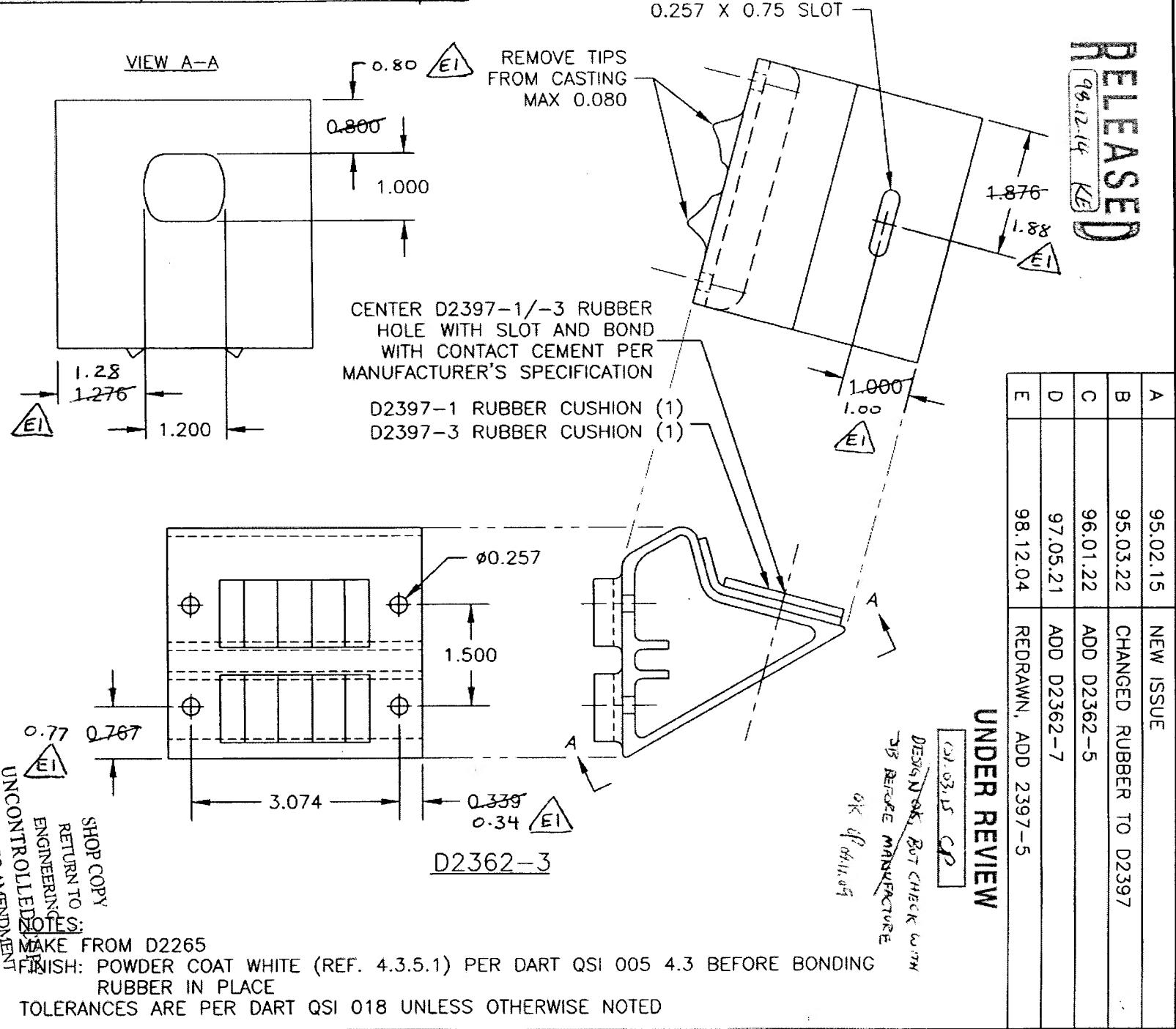
# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article Prototype

Measured by:	<u>GJL</u>	Audited by:	<u>J.L.</u>	Prototype Approval:	N/A
Date:	07/02/23	Date:	07/02/23	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.10.07	New Issue	KJ/RF	TT

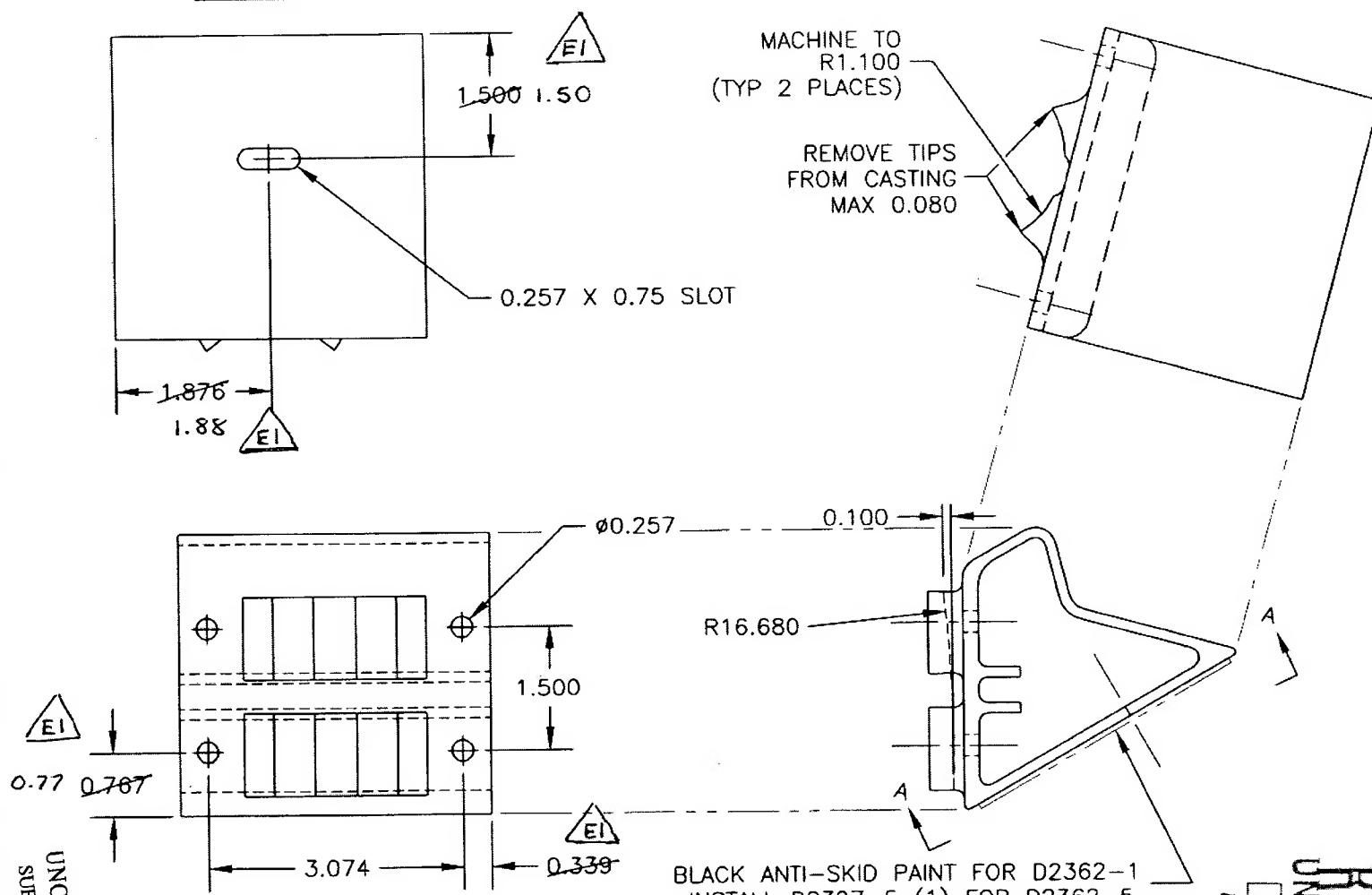
EL 03.10.07 TOLERANCE CHANGE ~~RF~~



DESIGN BW	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>KE</i>	APPROVED <i>KE</i>	DRAWING NO. D2362
DATE 98.12.04	STEP SUPPORT BRACKET	SCALE 1:2
A 95.02.15	NEW ISSUE	
B 95.03.22	CHANGED RUBBER TO D2397	
C 96.01.22	ADD D2362-5	
D 97.05.21	ADD D2362-7	
E 98.12.04	REDRAWN, ADD 2397-5	



VIEW A-A



WORK ORDER NO. 30877  
SUBJECT TO AMENDMENT  
UNCONTROLLED  
MADE COPY  
ENGINEERS  
RETURN TO  
COPYS  
D2362-1: BLACK ANTI-SKID PAINT PER DART QSI 005 4.4  
D2362-5: INSTALL D2397-5 RUBBER CUSHION. ALIGN RUBBER HOLE WITH SLOT  
AND BOND USING CONTACT CEMENT PER MANUFACTURER'S SPECIFICATION  
FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3  
BEFORE ANTI-SKID PAINT OR BEFORE INSTALLING D2397-5  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**DART**

DA COPY  
SUEO

DESIGN	DRAWN BY	DART AEROSPACE LTD
BW	CP	HAWKESBURY, ONTARIO, CANADA
CHEKED	APPROVED	DRAWING NO.
K	MF	D2362
DATE		SHEET 2 OF 3
98.12.04		SCALE
		1:2
		STEP SUPPORT BRACKET

**RELEASED  
12-14-98  
UNDER REVIEW**

Designok, but check w/  
JRS before manufatur.  
OK CP  
P.M.C.

D2362-041 (SHOWN)

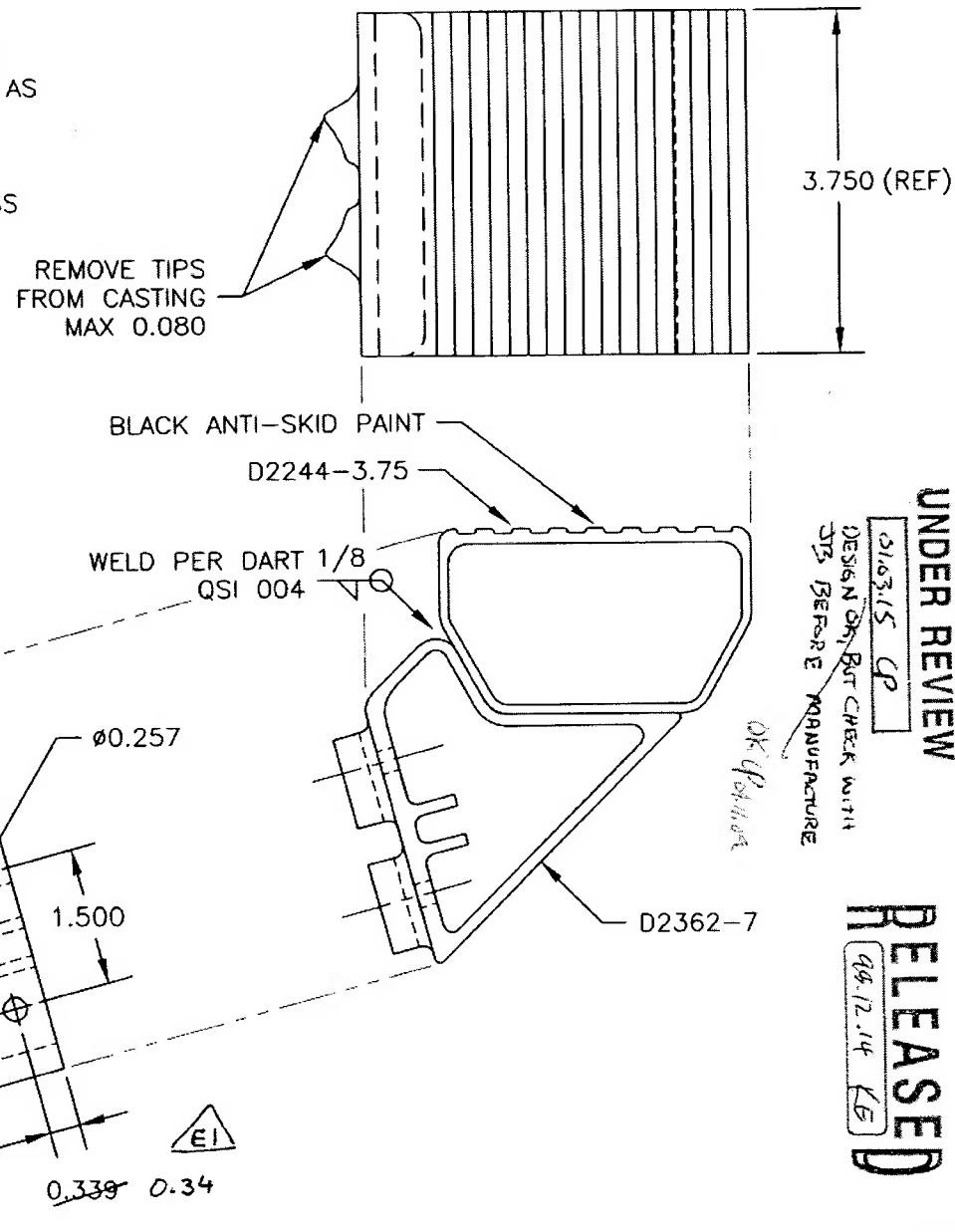
FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER  
QSI 005 4.3  
ANTI-SKID PAINT PER QSI 005 4.4 AFTER  
POWDER COATING

D2362-7 (SHOWN AS PART OF D2362-041)

MAKE FROM D2265 CASTING. DRILL D2265 AS  
SHOWN IN D2362-041 ASSEMBLY

NOTES:

TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED



**DART**

COPY IS  
OCT 1995

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
BW	APPROVED	REV. E
RE	MM	DRAWING NO. D2362
DATE	98.12.04	SHEET 3 OF 3 SCALE 1:2

UNDER REVIEW

516315 CP

DESIGN OK But CHECK WITH

J3 BEFORE MANUFACTURE

RELEASED  
48.12.14 EG

WORK ORDER  
NO. 30817  
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE